

skit

Date: Thursday, 6/7/2007 3:30:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Job Number	: 32858		
Estimate Number	: 10058		
P.O. Number	: <i>N/A</i>	Part Number	: D2622120C
This Issue	: 6/7/2007	Drawing Number	: D2622 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: C1
Previous Run	: 31984	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 6/30/2007
Checked & Approved By	: <i>[Signature]</i> 07.06.08	Qty:	<i>121</i> Um: Each
Comment	: Est. A: 02.11.12 New Issue KJ/RF		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *3937*

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C 207/06/08

(40 121)

2.0 D2622120CP Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s)
Extrusion

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
- Ensure material certification is attached

207/7/9 (132)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

- Inspect dimension per Dwg D2622
- Check Pull test per Dwg D2622 for compliance page attached
- Check hardness with Webster tester

207.18

72+60 = 132
counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 21/7/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 32858

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

Description :

50

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

PK - 07-07-19 (72)

60

QC21

FINAL INSPECTION/W/O RELEASE



07.07.20 *H*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

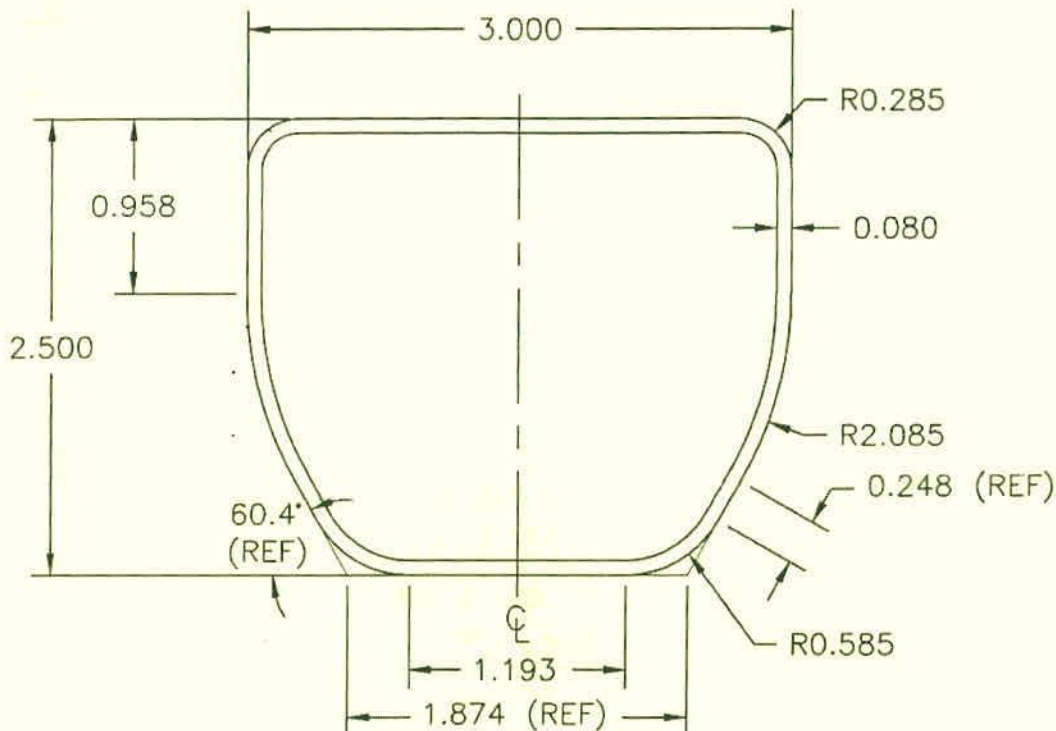
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries




DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
C1	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32858

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BON L CANADA INC.

THE WILLIAM L. BONNELL COMPANY, INC.
BON L MANUFACTURING COMPANY
SUBSIDIARIES OF TREDEGAR CORPORATION
FILIALES DE LA CORPORATION TREDEGAR



BON L CANADA INC
500 EDWARD AVENUE
RICHMOND HIL ON

L4C 4Y9

INVOICING COMPANY AND LOCATION
BUREAU DE FACTURATION

SHIPPING MANIFEST BORDEREAU D'EXPÉDITION

MANIFEST DATE/DATE D'EXPÉDITION

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

MANIFEST NUMBER/N° D'EXPÉDITION

SALES ORDER/NUMBER/N° DE COMM.

SHIP TO/EXPÉDIE À
ACCT# 00046024

ART AEROSPACE LTD.
270 ABERDEEN ST.
AWKESBURY
6A 1K7

ON
CN

SOLD TO/VENDU À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY
K6A 1K7

ON
CN

O/P

CREDIT REP
REP. DU CRÉDIT
HAMBROOK, PAU
905-508-3250

SALES REP
REP. DES VENTES

HONE 613-632-5200

PHONE 613-632-5200

STOMER ID/N° DU CLIENT ORDER DATE DATE DE LA COMMANDE CUST. PO. NO./N° DE COMM. DU CLIENT JOB/PROJET

46024 06/08/07 3937

RIH 67394 59358

BILL OF LADING NUMBER/N° DE CONNAISSANCEMENT

00349565

FIELD SALES REP
REP. RÉGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP. SERVICE CLIENTÈLE
Burton D
905-427-2227

ITEM NO. ITEM	ORDER QUANTITY QTE COMMANDEE	UNIT UNITÉ	PREVIOUS SHIPPED QTY. QTE DÉJÀ EXPÉDIÉE	MFG. PART NUMBER N° DE PIÈCE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMPÉ LENGTH LONGUEUR CUTTING TOLERANCE TOLÉRANCE DE COUPE	FINISH DESCRIPTION DESC. DE LA FINITION FABRICATION DESCRIPTION TYPE DE FABRICATION SHIPPING TOLERANCE TOLÉRANCE D'EXPÉDITION	THIS SHIPMENT/CETTE EXPÉDITION			UNIT UNITÉ	QUANTITY DU QUANTITÉ PRÉV
							NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
01	121	KG M PC	0 0 0	DAA-897123-1 D2622	6061 /T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMF (+015-015,0139-0102)	2	575	554 402.34 132	KG M PC	
					DETAIL: LOT/TICKET	74203010 / 172427 74203010 / 172428	1 1	313 262	302 252		72 P 60 P 132

ORM NO. B1085 REV. C
NO RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION
AUCUN RETOUR DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

CUSTOMER
CLIENT

PAGE

1

TOTALS/TOTAUX

575 554 KG
402.34 M
132 PC

**BON L CANADA INC**500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No	Sales Order	Page
07/06/07	162381	74203	1
Cust PO	R/I No	Lot	Date
3937	00349565	74203010	7/06/07

Sold To	46024	Ship To	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	575 KGS
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Net Qty	554 KG	132 PC	402 M	2 PKG
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Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	291.8 / 42.3	251.8 / 36.5	10.2	.0	93

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.62	.26	.24	.01	.86	.05	.011	.07	.000	.006	.01	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

